

Date: Tuesday, 22/04/2008 3:53:57 PM  
 User: Julia Lecocq

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : LOW PROFILE BASKET LID ASS'Y
<b>Job Number</b> : 38763	
<b>Estimate Number</b> : 13153	
<b>P.O. Number</b> :	<b>Part Number</b> : D3713042
<b>This Issue</b> : 22/04/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3713 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 38461	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 12/05/2008 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>Jul 09.4.23</u>	
<b>Comment</b> : Est Rev:A new issue 08-01-30 DD verified by:EC	
Est Rev:B change to revB ecn 1145 08-03-19 DD verified by:	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
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**Comment:** Qty.: 32.5731 f(s)/Unit Total: 32.5731 f(s)  
 304 SQ Tube.75x.75x.065W

1- Cut Ribs as per dwg from 3/4" x 3/4" x 0.065 wall 304/316 SS tubing.

QTY PART NUMBER BATCH

2	D3714-1	<u>M107515</u>
2	D3715-1	<u>M107515</u>
10	D3716-1	<u>M107515</u>
4	D3732-1	<u>M107515</u>

2- Deburr

SAD 08/04/29 (1)

2.0	D23271	Spacer Bushing
-----	--------	----------------



**Comment:** Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)  
 Spacer Bushing  
 batch 31851336920V

SAD 08/04/29

3.0	D2581	Mounting Bracket
-----	-------	------------------



**Comment:** Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)  
 Mounting Bracket  
 batch B37248 → 2 ✓

SAD 08/04/29

(PTO)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3713-042 PAR #: N/A Fault Category: Prod / Ex. Large NCR: Yes No DQA: D Date: 08/05/12  
D205-541 QA: N/C Closed: D Date: 08/05/12

NCR: <u>38763</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>080506</u>	<u>3.0</u>	<u>Scrap 1 D2581 337248</u> <u>WRONG POSITION</u> <u>HUMAN ERROR</u> <u>(QTY 1)</u>	<u>[Signature]</u>	<u>Re position in correct location and Re weld Q57004</u> <u>D2581 B# 37219</u>	<u>[Signature]</u> <u>08/05/12</u> <u>080506</u>	<u>[Signature]</u> <u>08/05/12</u>	<u>[Signature]</u>	<u>[Signature]</u> <u>08/05/12</u>
		<u>- was it measured -</u>						<u>[Signature]</u> <u>08/05/12</u>

NOTE: Date & initial all entries

Date: Tuesday, 22/04/2008 3:53:57 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LOW PROFILE BASKET LID ASS'Y

Job Number: 38763

Part Number: D3713042

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

D37491

Hinge Half



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

HINGE HALF

batch

*B37202 → 1 ✓ B38826 → 2 ✓ LJS 08/04/29*

5.0

D2329

Label Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Label Plate

batch

*~~B35685~~ B35686 ✓ LJS 08/04/29*

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- drill holes in both D3715-1 as per dwg D3715

2- deburr

3- assemble as per dwg D3713 and weld as per QSI004

*Pl 08.05.05  
LJS 08/04/29  
SAD 08/04/29*

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 17.8500 sf(s)/Unit Total : 17.8500 sf(s)

Expanded Metal Flat Stainless Steel

Pick:

Qty

Part Number

Description

Batch

17sq.ft M304EX0.75-16F

Expanded Metal

*M107316 ✓ Pl 08.05.05*

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- cut mesh as per dwg D3743

2- weld mesh as per dwg D3713

*Pl 08.05.06*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 22/04/2008 3:53:57 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LOW PROFILE BASKET LID ASS'Y

Job Number: 38763

Part Number: D3713042

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

9.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

AD 08-05-06

10.0	QC9	VISUAL WELDING INSPECTION
------	-----	---------------------------



Comment: VISUAL WELDING INSPECTION

AD 08-05-

338763

D3713042

17/05/2008

11.0	POWDER COATING	POWDER COATING
------	----------------	----------------



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M 100700

AD 08-05-06

S.205 13.30

#1 325.3 F

#2 --- F

#3 30mm F

#4 --- F

12.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
------	-----	-----------------------------------------



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ 08/05/07 @

P15

13.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
------	-----------------	----------------------------



Comment: Wing Walk as per Dwg D3713 and QSI 005 4.4

M 107380

AD 08/05/07 @

08/05/07 @

14.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
------	-----	-----------------------------------------



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

CB 08/05/08 @

15.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

P1P 38732

AD 08/05/09 @

16.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

08/05/12

Job Completion



AD 08-05-09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
0060508	135	Amover sheet over cable on lid.	<i>[Signature]</i>	080508	1	<i>[Signature]</i>	<i>[Signature]</i>
			<i>[Signature]</i>	08/05/08		<i>[Signature]</i>	08/05/08

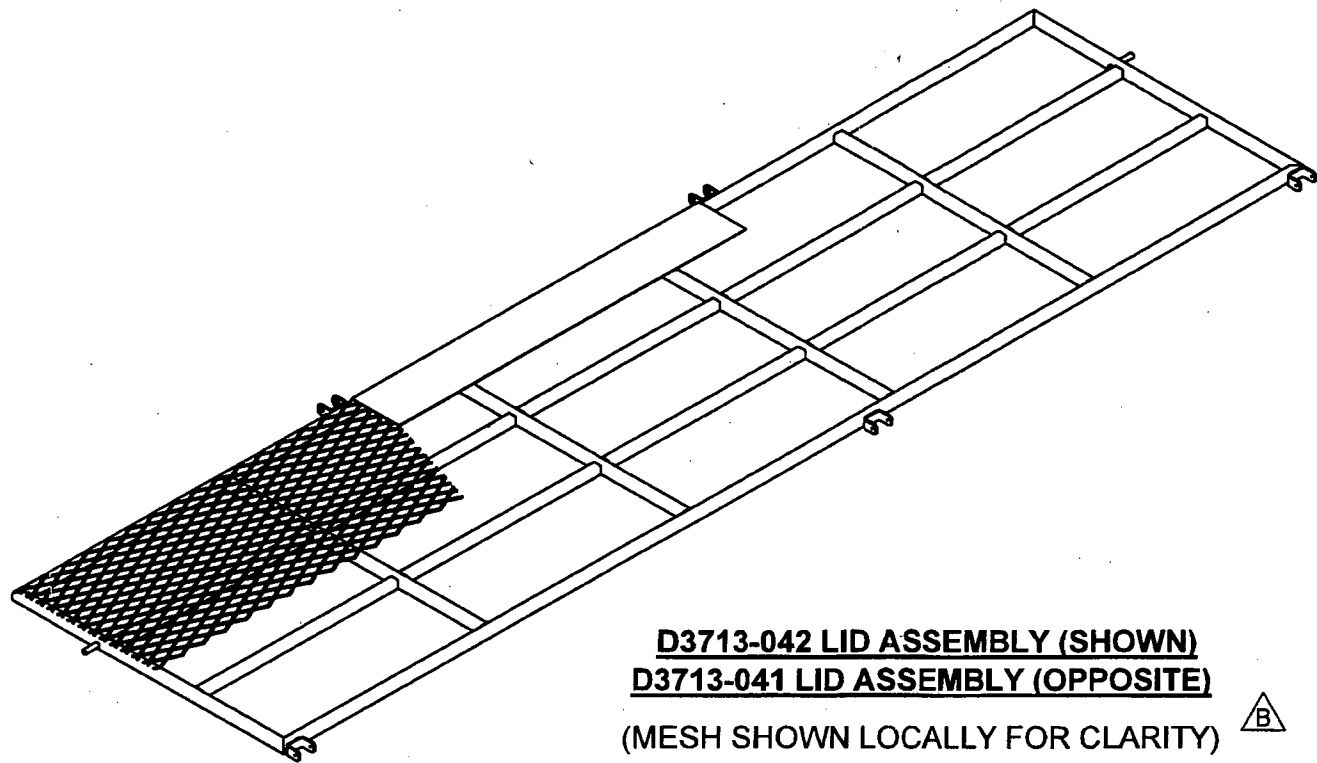
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3713-041	LID ASSEMBLY
	X	D3713-042	LID ASSEMBLY
2	2	D2327-1	SPACER
1	1	D2329	LABEL PLATE
2	2	D2581	MOUNTING BRACKET
2	2	D3714-1	RIB
2	2	D3715-1	RIB
10	10	D3716-1	RIB
4	4	D3732-1	RIB
1	1	D3743-1	MESH
3	3	D3749-1	HINGE HALF



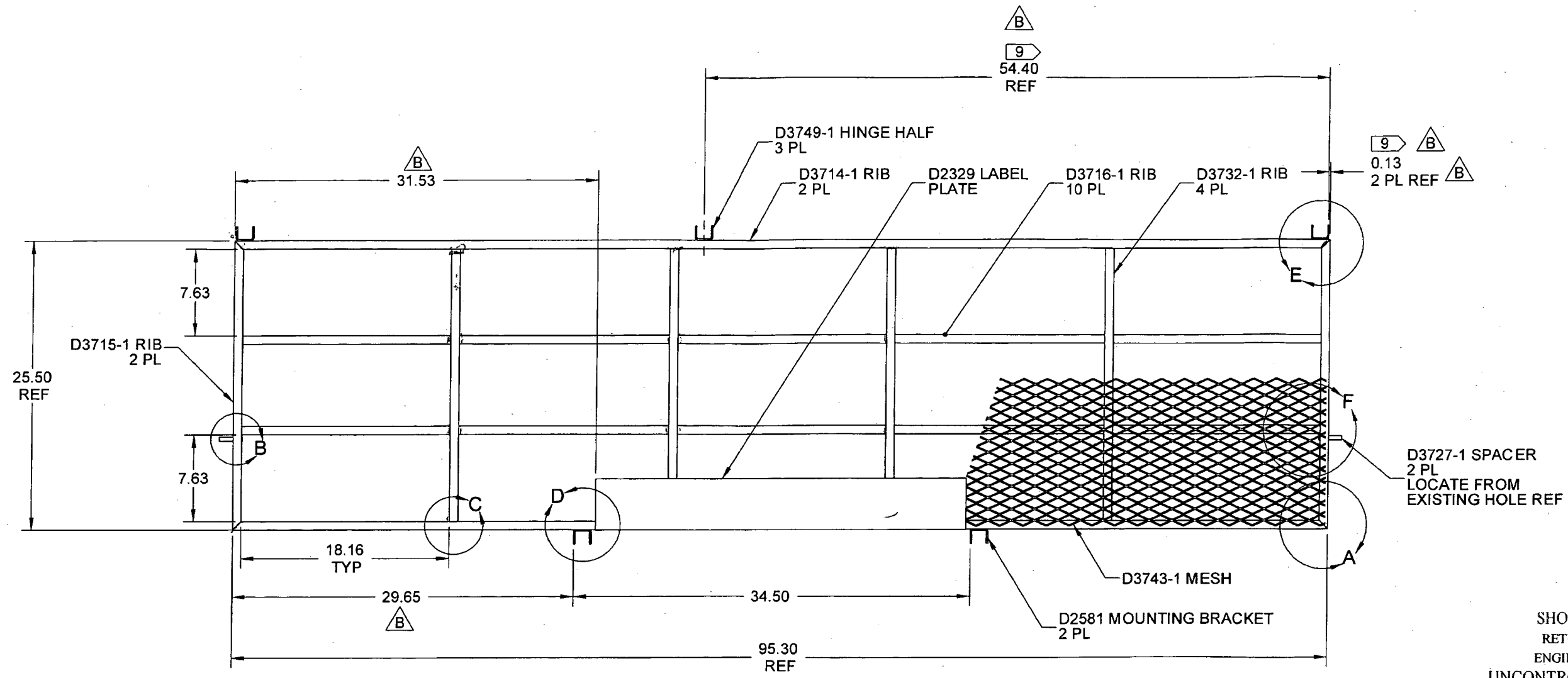
**D3713-042 LID ASSEMBLY (SHOWN)**  
**D3713-041 LID ASSEMBLY (OPPOSITE)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**NOTES:**

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004
- 9) CENTER D3749-1 HINGE HALF ON D3748-1 HINGE HALF ON D3712-041/042 BASKET BASE ASSEMBLY

B	SHEET 1 -042 WAS -041; ADDED CORRECT -041 ASSEMBLY, NOTE 9 ADDED, ZONE C2 LID ASSEMBLY WAS D3713-041. WEIGHT WAS 36 lbs. SHEET 2 ZONE B5 LID ASSEMBLY WAS D3713-041, ZONE D6 31.53 DIM WAS 31.64, ZONE D3 54.40 DIM NOW REF ZONE D2 0.13 REF DIM ADDED ZONE B6 29.65 DIM WAS 29.77, ZONE D3 & D2 FLAG NOTE 9 ADDED.	AJS	08.02.27
A	NEW ISSUE	AJS	08.02.01
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CE	DRAWING NO.	REV. B
MFG. APPR.	DS	D3713	SHEET 1 OF 3
APPROVED	140	TITLE	SCALE
DE APPR.	TH	LID ASSEMBLY	NTS
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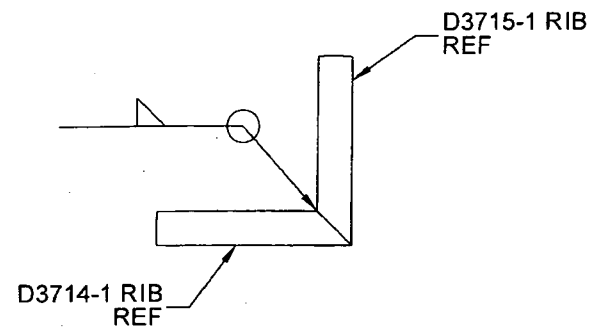


**D3713-042 LID ASSEMBLY (SHOWN)** B  
**D3713-041 LID ASSEMBLY (OPPOSITE)**  
 (MESH SHOWN LOCALLY FOR CLARITY)

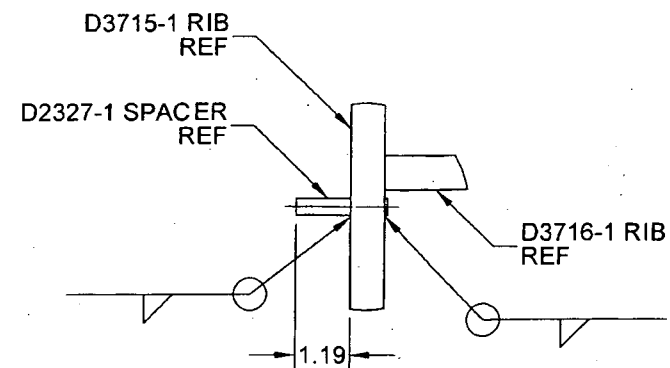
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APPROVED	<i>[Signature]</i>	TITLE	SCALE
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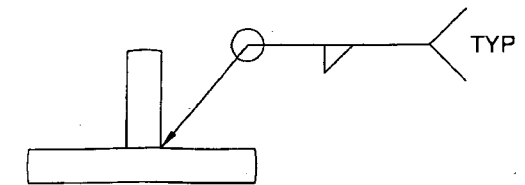




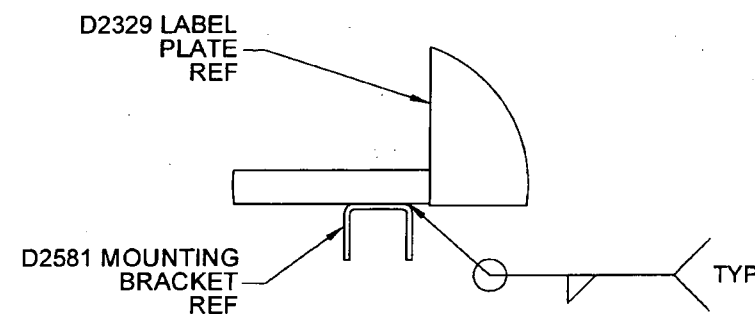
**DETAIL A: TYP CORNER WELDS**  
SCALE 4X  
(MESH NOT SHOWN FOR CLARITY)



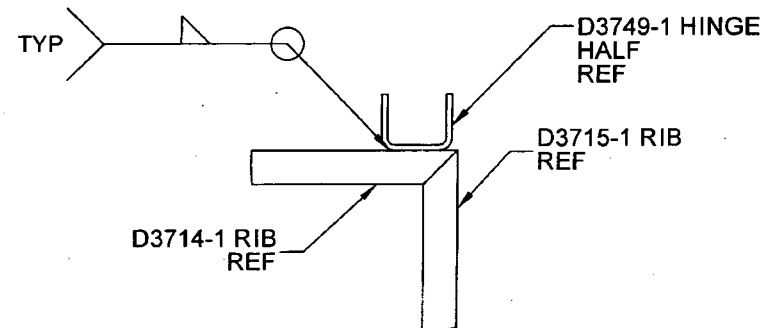
**DETAIL B**  
TYP BOTH ENDS  
SCALE 4X



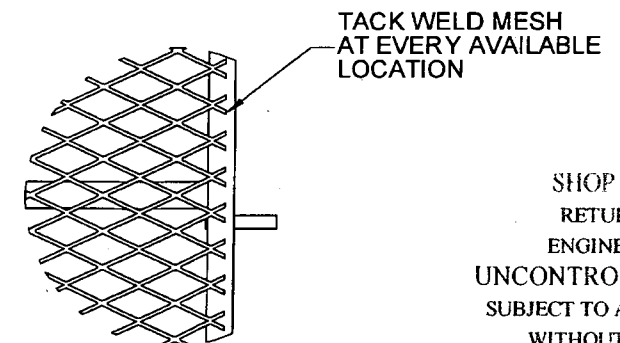
**DETAIL C**  
TYP  
SCALE 4X



**DETAIL D**  
SCALE 4X



**DETAIL E**  
SCALE 4X



**DETAIL F**  
SCALE 5X

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05.03.17 MP

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MFG. APPR.	AE	D3713	SHEET 3 OF 3
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1

D

D

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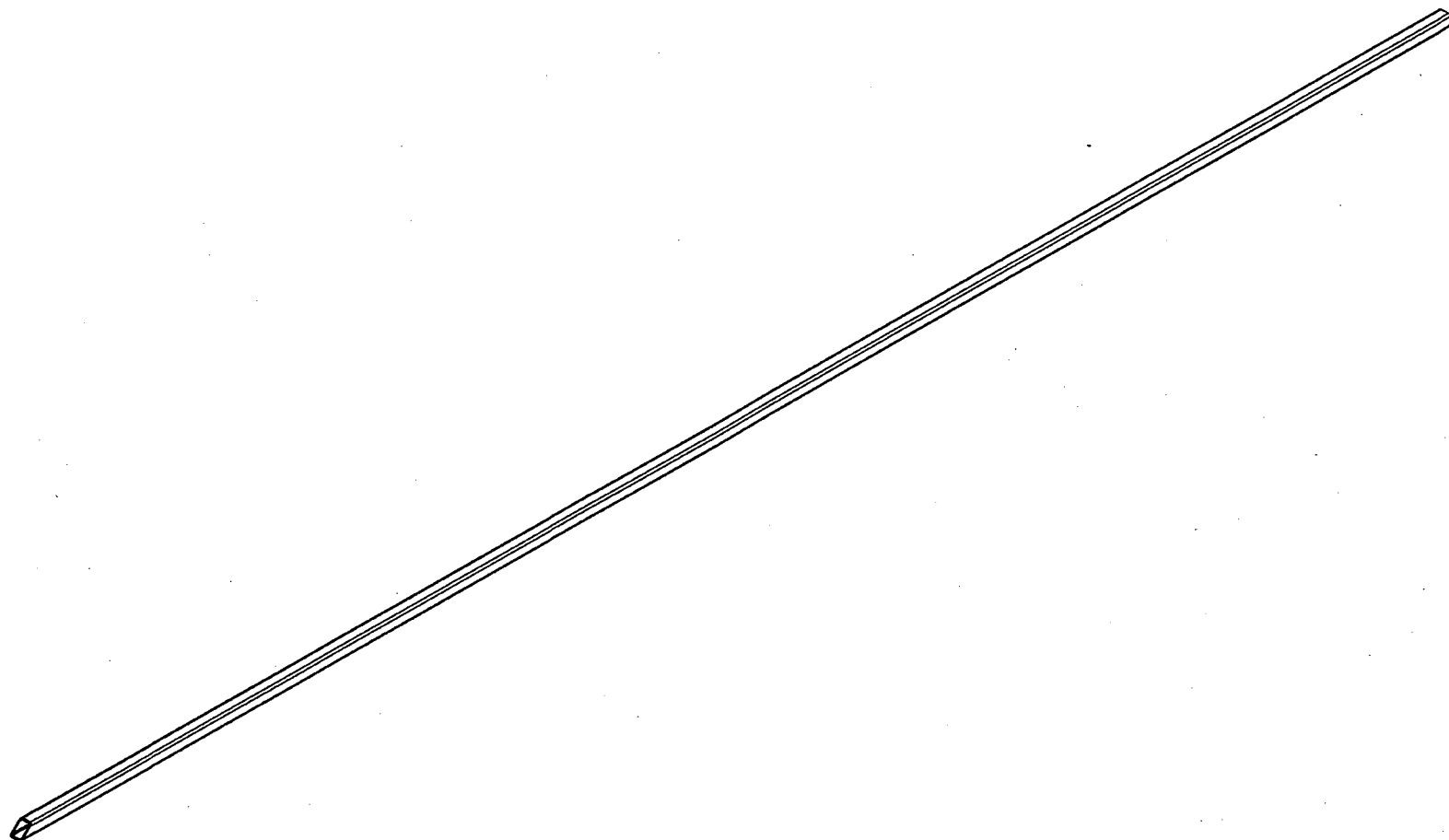
C

B

B

A

A

**D3714-1 RIB**

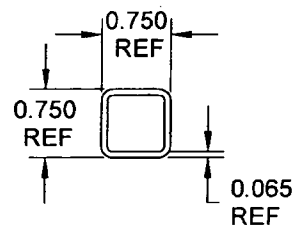
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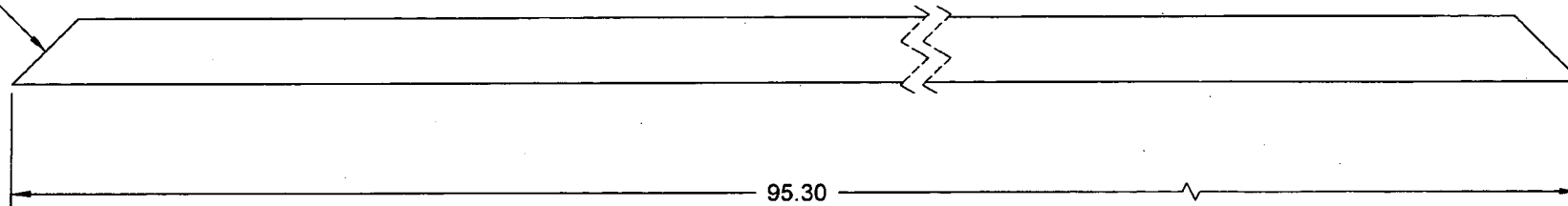
**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
(REF. DART SPEC. M304TS0.750W0.065)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.54 lbs

A	NEW ISSUE		AJS	08.02.01
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
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CHECKED	LE	DRAWING NO.	REV. A	
MFG. APPR.	MD	D3714	SHEET 1 OF 2	
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0.75 X 45° CMF  
2PL

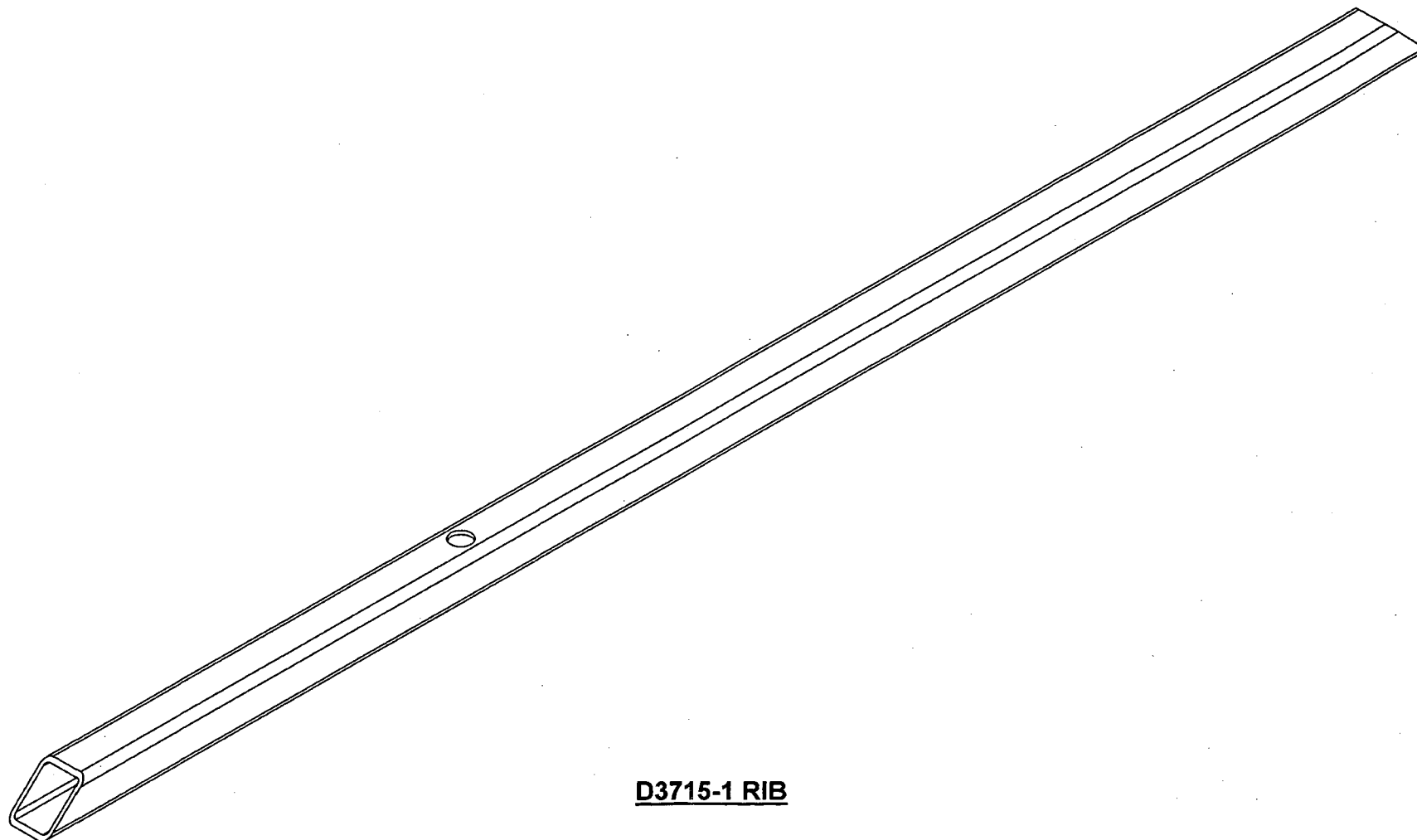


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MFG. APPR.	MP	D3714	SHEET 2 OF 2
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**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
(REF. DART SPEC. M304TS0.750W0.065)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.18 lbs

A	NEW ISSUE		AJS	08.02.01
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MFG. APPR.	ADP	D3715	SHEET 1 OF 2	
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0.75 X 45° CMF  
2 PL

25.50

Ø0.375  
THRU

0.38

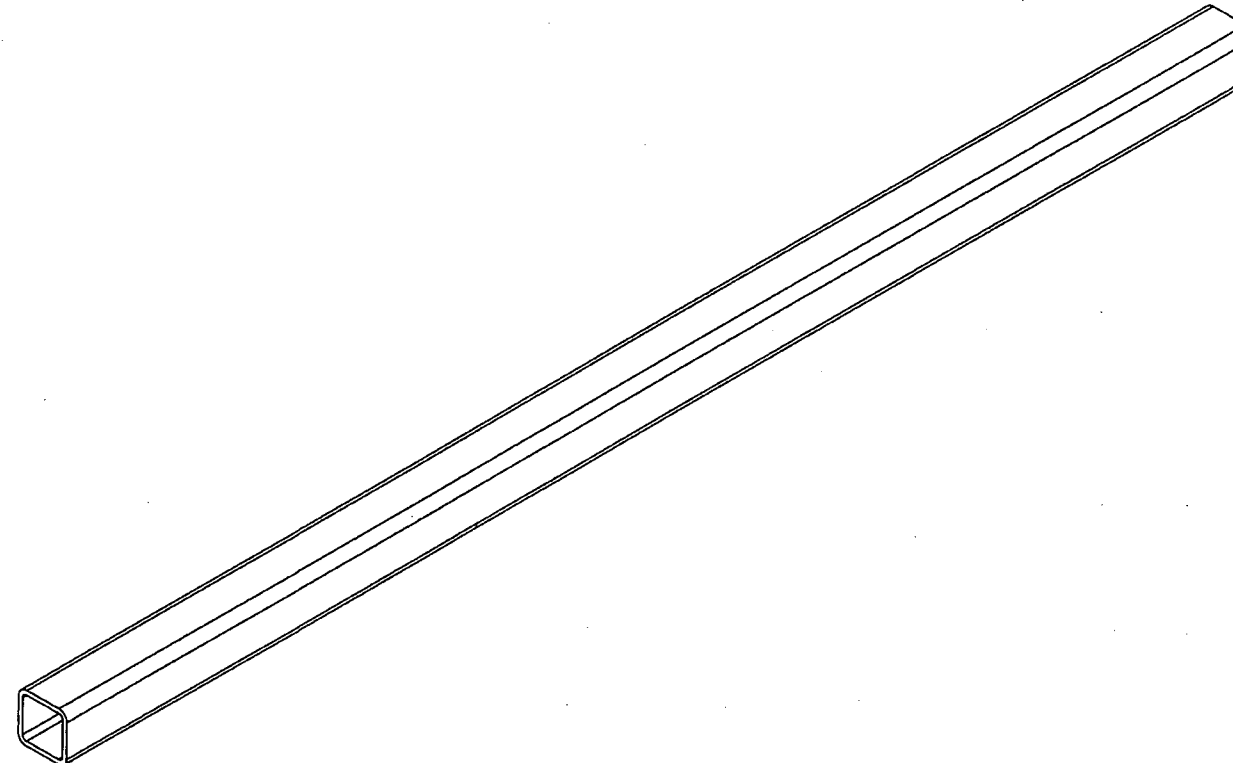
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MFG. APPR.	LE	<b>D3715</b>	SHEET 2 OF 2
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DE APPR.	LE	<b>RIB</b>	1:2
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**D3716-1 RIB**

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NO. 38763

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16-08-225

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
(REF. DART SPEC. M304TS0.750W0.065)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.87 lbs

A	NEW ISSUE	AJS	08.02.01
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	UE	DRAWING NO.	REV. A
MFG. APPR.	MS	D3716	SHEET 1 OF 2
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8

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4

3

2

1

D

D

C

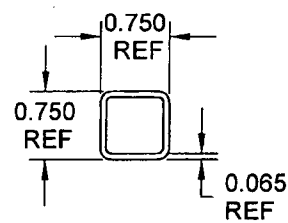
C

B

B

A

A



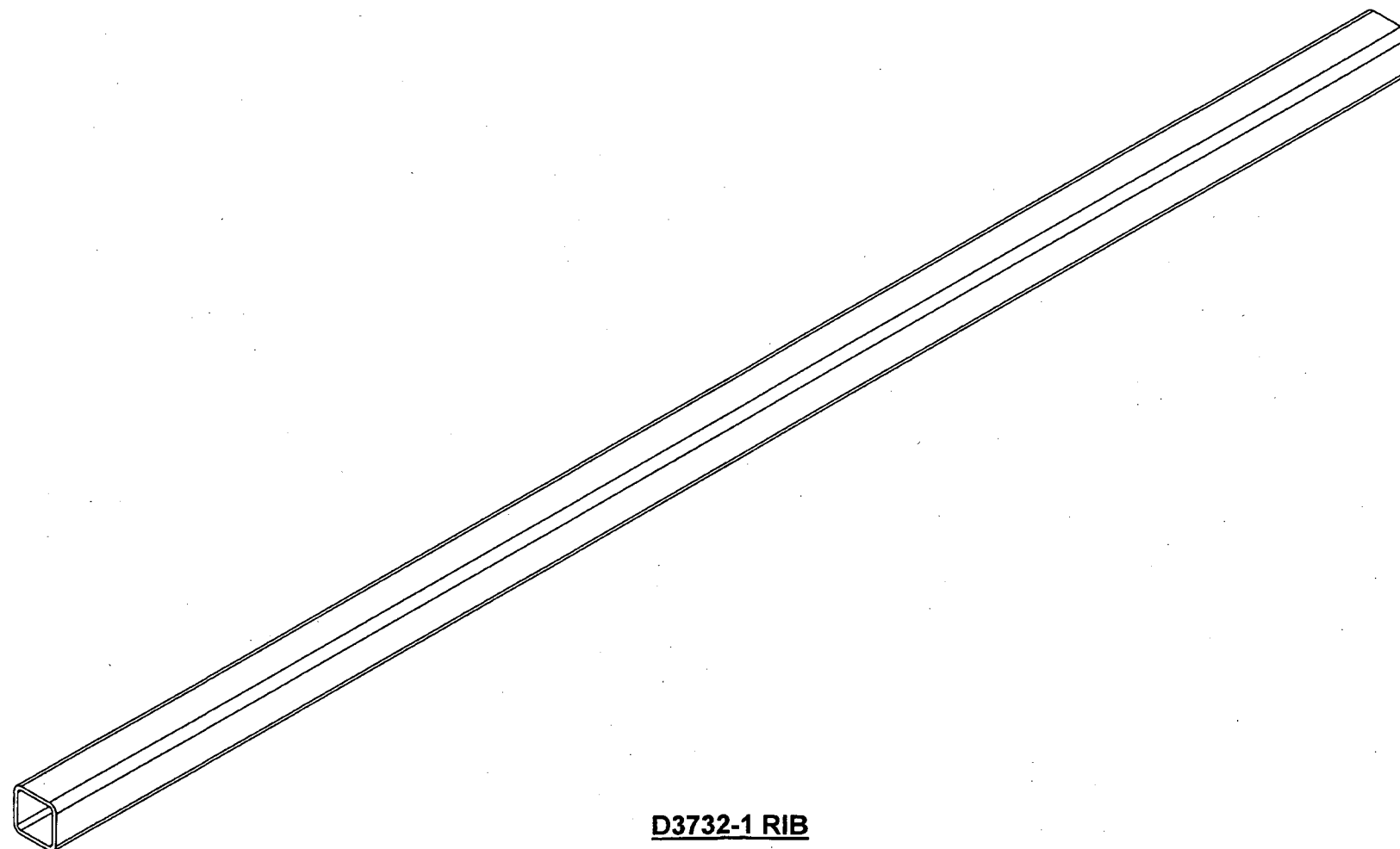
18.16

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DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	ASS		
CHECKED	LE	DRAWING NO.	REV. A
MFG. APPR.	WJF	D3716	SHEET 2 OF 2
APPROVED	WJF	TITLE	SCALE
DE APPR.	WJF	RIB	1:2
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**D3732-1 RIB**

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- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
(REF. DART SPEC. M304TS0.750W0.065)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 1.15 lbs

A	NEW ISSUE	AJS	08.02.01
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	LE	DRAWING NO.	REV. A
MFG. APPR.	LE	D3732	SHEET 1 OF 2
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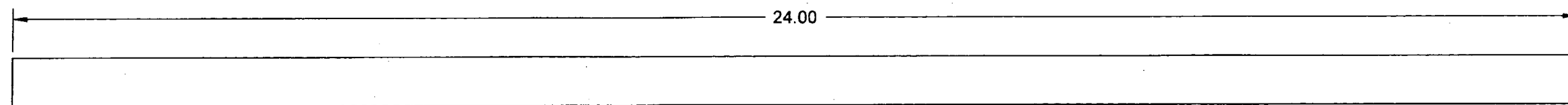
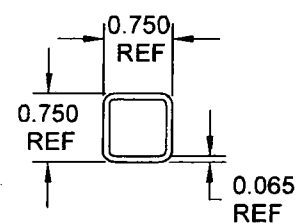
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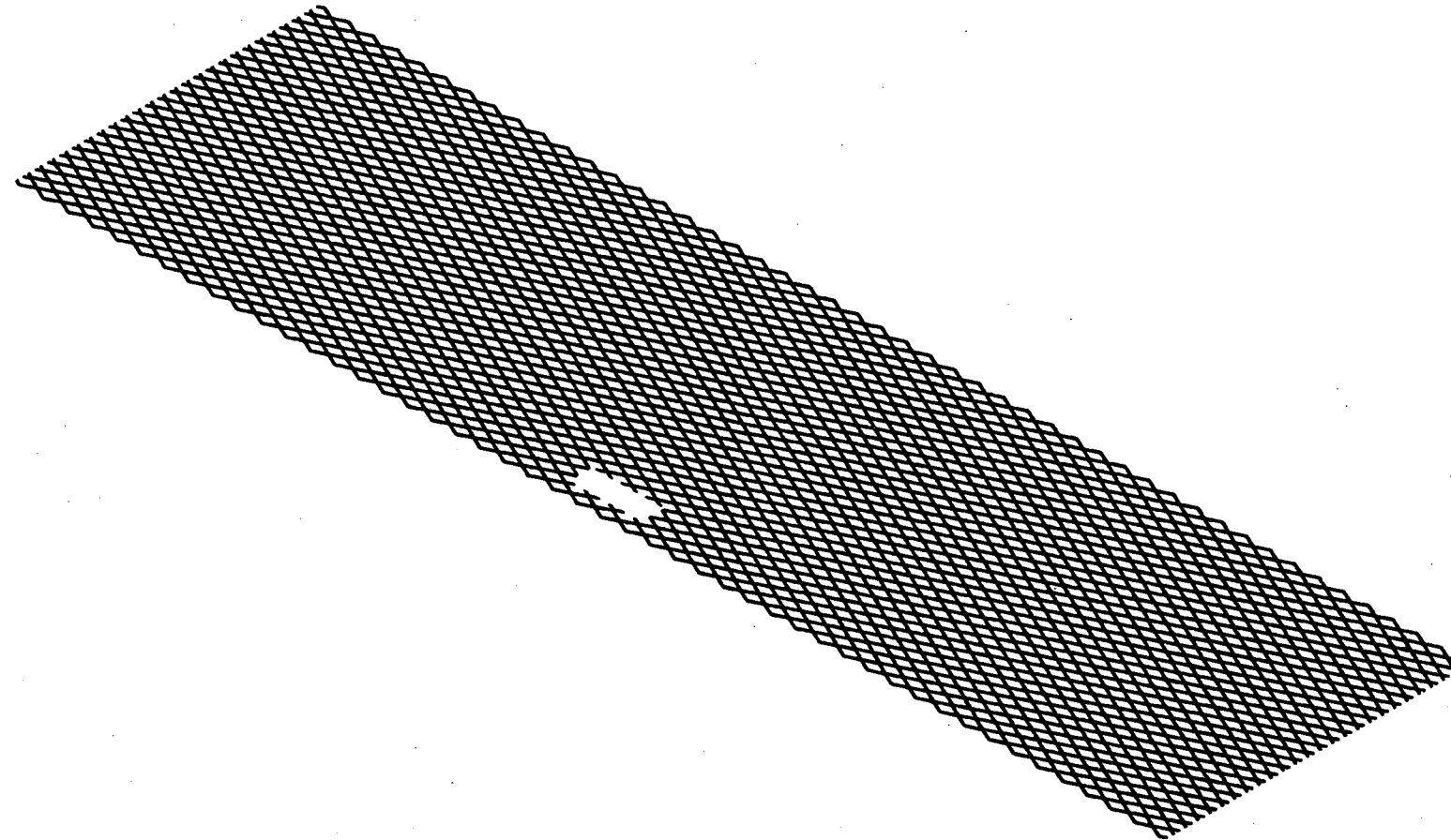
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**D3743-1 MESH**

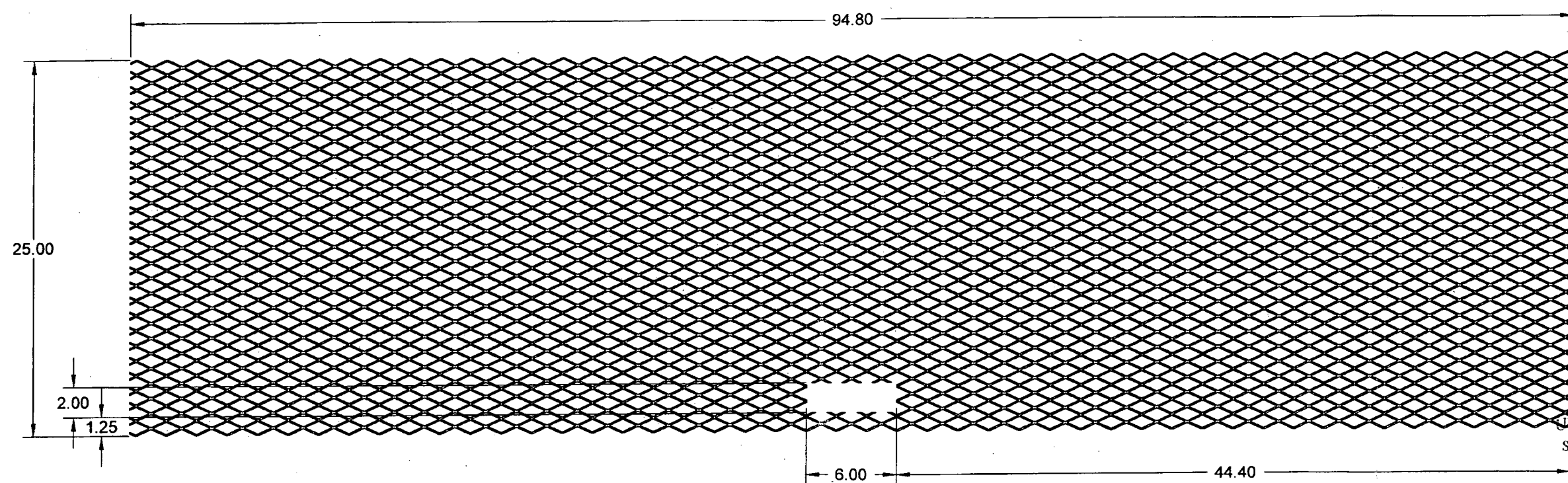
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**NOTES:**

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH, 3/4-16F  
(REF. DART SPEC. M304EX0.75-16F)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 8.7lbs APPROX

A	NEW ISSUE		AJS	08.02.01
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MFG. APPR.	MP	D3743	SHEET 1 OF 2	
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